

Date: Thursday, 7/3/2008 3:32:32 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MANIFOLD TUBE ASSEMBLY
Job Number : 40227	
Estimate Number : 13447	
P.O. Number :	Part Number : D2127251931
This Issue : 7/3/2008 S.O. No. :	Drawing Number : D212-725-1 PG46
Prsht Rev. : NC :	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run :	Material :
Written By : <u>JA 08 07.04</u>	Due Date : 7/10/2008 Qty: <u>5</u> Um: Each
Checked & Approved By : <u>JA 08 07.04</u>	
Comment : Est Rev:A New Issue 08-07-03 EC vrified by DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W
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Comment: Qty.: 2.9715 f(s)/Unit Total : ~~5.9430 f(s)~~

304 RD Tube 1.0" x .049W

BATCH: M 107950

14.0575

FF 08-07-07

5

2.0	AN81816J	Nut
-----	----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2.0000 Each(s)~~

Nut

Batch: M 104715

5.0000

FF 08-07-07

5

3.0	MS2081916J	Sleeve
-----	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2.0000 Each(s)~~

Sleeve

Batch: M 107649

5.0000

FF 08-07-07

5

4.0	M304S18GA	304/316 .050 Sheet
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Comment: Qty.: 0.0159 sf(s)/Unit Total : 0.0317 sf(s)

304/316 .050 Sheet

batch: 100997

8-7-14

5.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:32:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MANIFOLD TUBE ASSEMBLY

Job Number: 40227

Part Number: D2127251931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

~~1-Bend~~ 1-Bend D212-725-141 as per dwg

8/07/22 (10)

2-Form as per Dwg D212-725-1 and Template DT8914.

3- Drill and flatten end per dwg D212-725-1

4-Flare end as per Dwg D212-725-1.

****ENSURE TO INSTALL SLEEVE & NUTS BEFORE FLARING****

FF 08-07-08 (5)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld flatten end and -141 brackets per dwg and template DT8914

08-07-23

(XS)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/07/23 (5)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/07/24 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AS Per Dwg 5/12/24 8/7/24 (5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24

Job Completion



11/07/24

Dart Aerospace Ltd

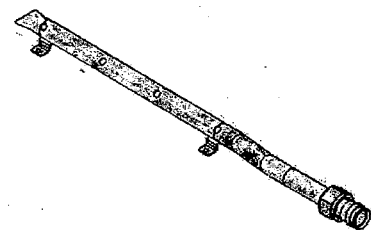
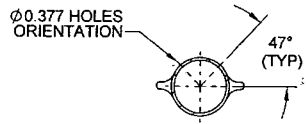
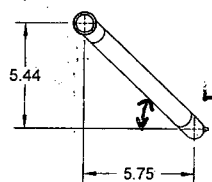
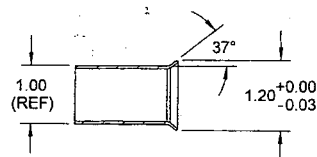
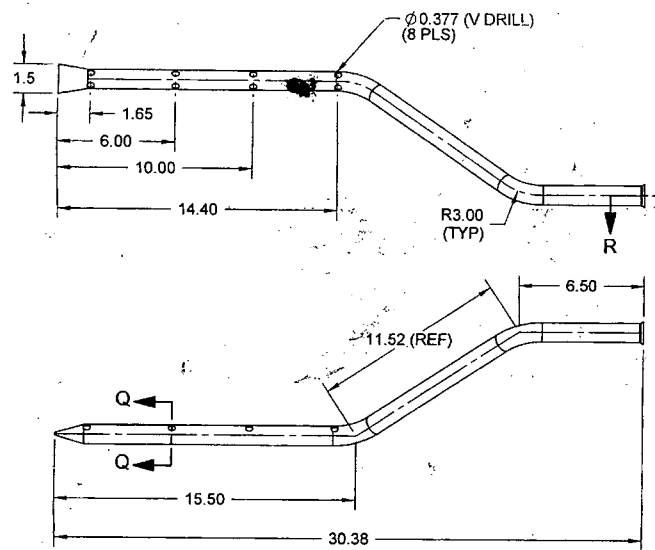
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
8/7/22	61	Qc S <i>08/07/22 (AW) perm. change</i>	<i>AW</i>	8/07/22			<i>08/07/22</i>	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

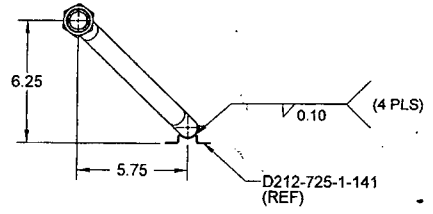
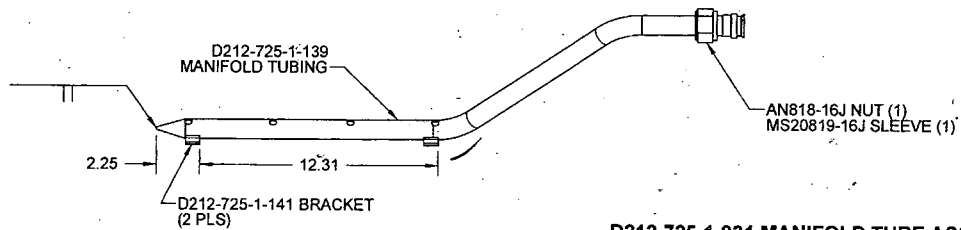
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D212-725-1-139 MANIFOLD TUBING
MANUFACTURE PER TEMPLATE DT8914






D212-725-1-931 MANIFOLD TUBE ASSY

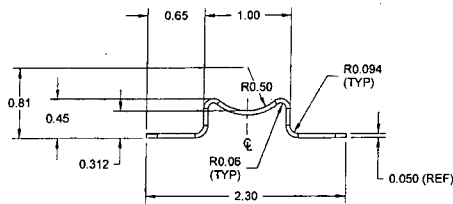
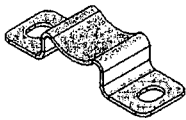
RELEASED
08-07-14

- NOTES:**
 1) MATERIAL: AISI 304/316 SS ϕ 1.00 x 0.049 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR1.000W.049)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D212-725-1-931 USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: N/A
 8) WELD PER DART QSI 004

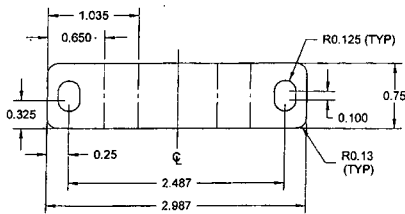
NO. 40027
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
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 ENGINEERING
 RETURN TO
 SHOP COPY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. C
MFG. APPR.		D212-725-1	SHEET 46 OF 49
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	1:6
DATE	07.12.04	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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W/O 40227

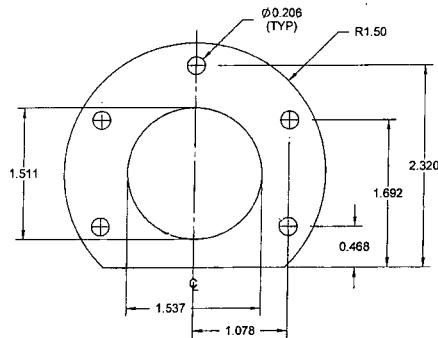


D212-725-1-141 BRACKET
(MAKE FROM D212-725-1-141F)



D212-725-1-141F FLAT PATTERN

- D212-725-1-141 NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.050 THICK (18 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S18GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: N/A



D212-725-1-143 BASE PLATE

- D212-725-1-143 NOTES:**
 1) MATERIAL: AISI 301/304 STAINLESS STEEL 1/4 HARD 0.032 THICK (22 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S22GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: N/A

RELEASED
08-07-14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAMMERSBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.		D212-725-1	SHEET 47 OF 48
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	1:1
DATE	07.12.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

